

Date: Thursday, 04/09/2008 1:23:02 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 L WEB		
Job Number	: 41821		Part Number	: D26547		
Estimate Number	: 10722		Drawing Number	: D2654 REV E1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 04/09/2008 S.O. No. :		Drawing Revision	: E1		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SKIDTUBES		Due Date	: 28/09/2008 Qty: 4 Um: Each		
Previous Run	: 41437					
Written By	:					
Checked & Approved By	: 2008-7-09					
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM					
	Est Rev:E 06.04.05 Added level21		EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26007140	EXT. "I BEAM" THICK	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number Description Batch	1 D2600-7- 140 Web <u>21966</u>	DT 08-09-09
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Cut D2600-7 to length as per Dwg D2654	
		2-Drill pilot holes in web using drill jig DT 8018-7 as perDwg D2654	
		3-Using the uni-bit, open holes to finish size as per Dwg D2654	
		4-Deburr holes and ends	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	8-9-9
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	
			DT 08-09-09 X4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 41821

Part Number: D26547

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		8-9-9-47
6.0	PACKAGING 1	PACKAGING RESOURCE #1
7.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: _____		
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

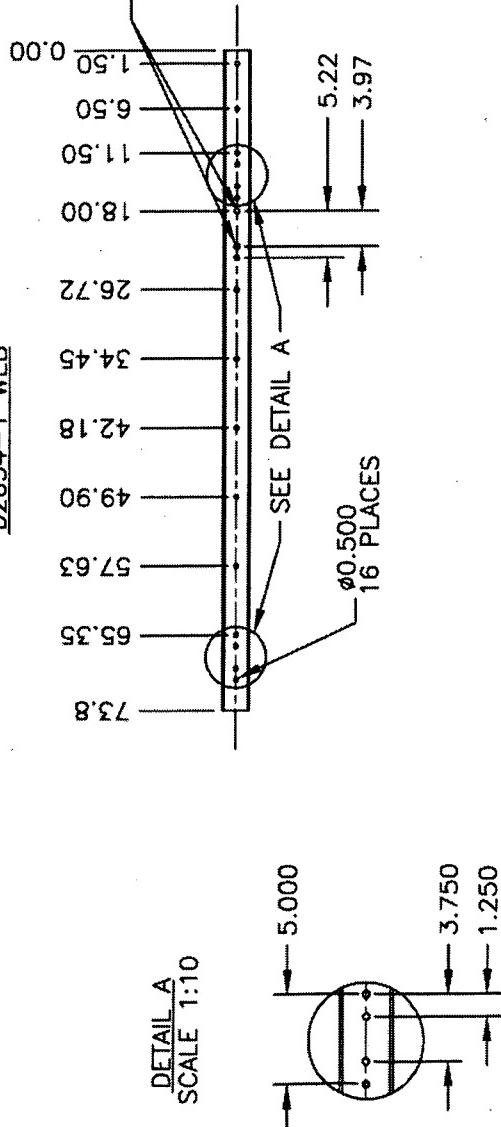
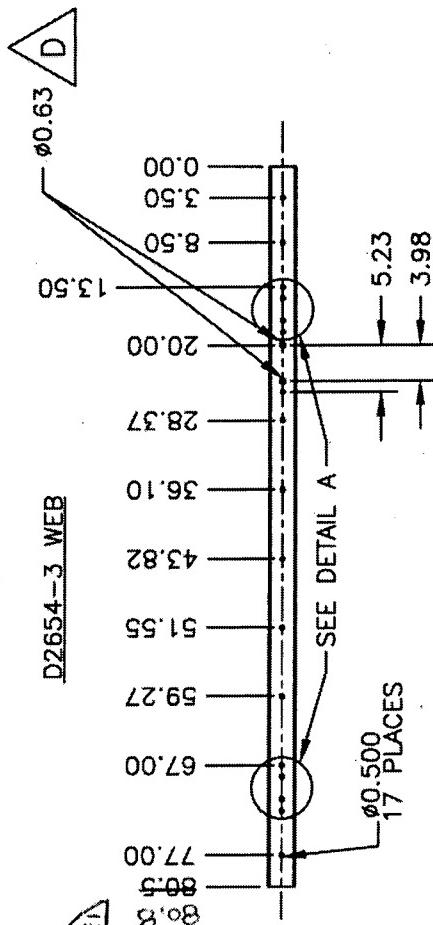
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DARTCOPY/6
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB SCALE 1:20

04.05.26

RELEASED
04.06.22D2654-1 WEBD2654-3 WEB

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

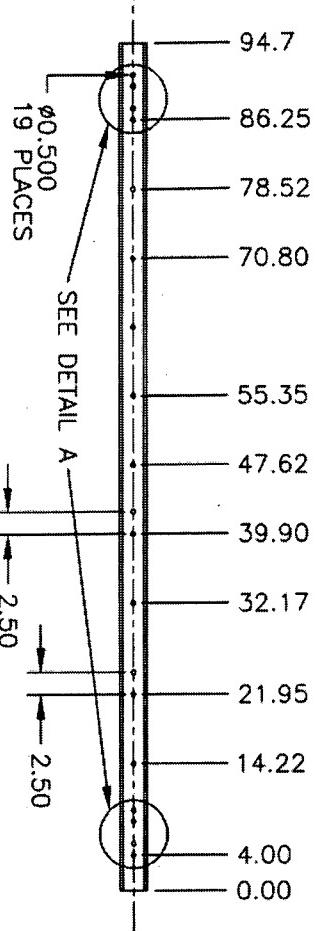
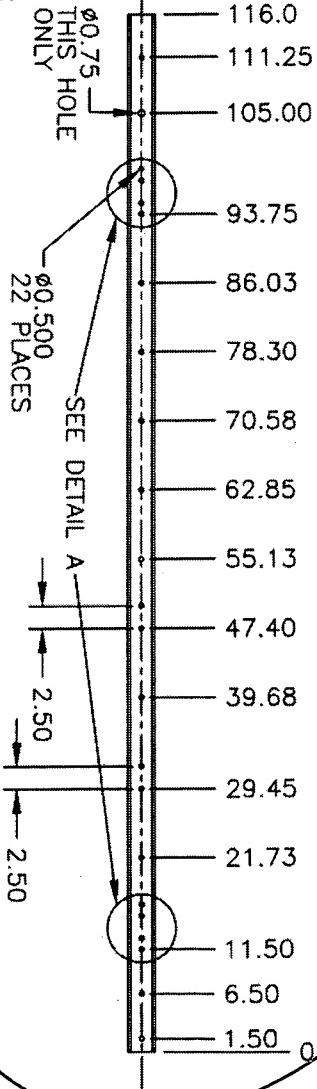
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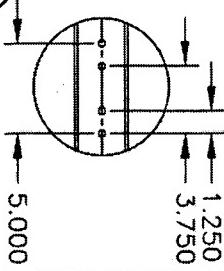
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MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL A
SCALE 1:10



DESIGN	DRAWN BY	WEB	DATE	04.05.26
CHECKED	APPROVED	FILE	DRAWING NO.	D2654
REV. E			SHEET 2 OF 2	
			SCALE	1:20

